

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-020505**Date Inspected:** 31-Jan-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 1500**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 300**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Mr. Chen Xi**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector,Baskar Govindarajan, was present during the times noted above for observations relative to the work being performed.

Bay #14

This QA Inspector observed the following work in progress

Shielded Metal Arc Welding (SMAW):

Repair welding of Weld joint-169, Located on Lift 14E, between Vertical Shear plate to Bottom plate, SEG3019BB, as per WRR no. B -CWR-2737. Welder is identified as 215553. ZPMC Quality Control Inspector (QC) is identified as Zhong Yong Hong. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-2G (2F)-FCM -Repair.

Flux Cored Arc Welding (FCAW)

Weld joint 047, Located on Lift 14E, Vertical shear plate to Anchor plate, SEG3019BB. Welder is identified as 066763. ZPMC Quality Control Inspector (QC) is identified as Gong Wei. The welding variables recorded by QC appeared to comply with the WPS-B-T-2233-ESAB.

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Weld joint 069, Located on Lift 14E, Vertical shear plate to Anchor plate, SEG3019BB. Welder is identified as 066099. ZPMC Quality Control Inspector (QC) is identified as Gong Wei. The welding variables recorded by QC appeared to comply with the WPS-B-T-2233-ESAB.

Bay #19

During a random observation this QA inspector observed the following components for the Orthotropic Bridge Girder (OBG) in Bay 19;

Suspender Bracket SB 106E, SB 106W, SB 108E

This QA observed that ZPMC was not performing any work on the above mentioned components during the time, this QA inspectors was present.

Bay #28

During a random observation this QA inspector observed the following components for the Orthotropic Bridge Girder (OBG) in Bay 28;

U Rib Splice plates:

SA3221A-031, SA3321-024, SA3321A -022, SA 7010B -002

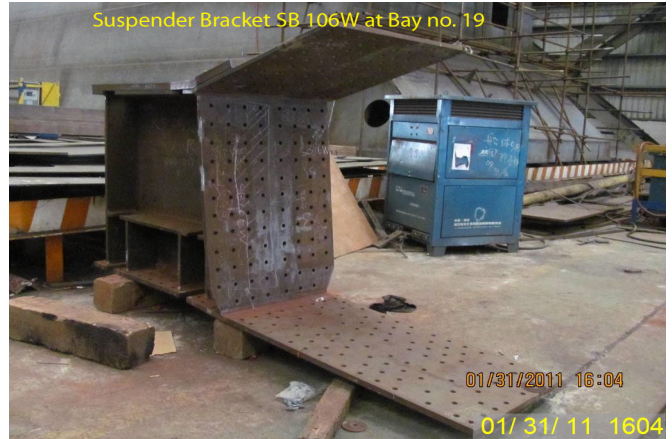
This QA observed that ZPMC was not performing any work on the above mentioned components during the time, this QA inspectors was present.

For further information see below pictures:-

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.

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Summary of Conversations:

No relevent Conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Thomas Hu (15002048250), who represents the Office of Structural Materials for your project.

Inspected By: Baskar, Govindarajan

Quality Assurance Inspector

Reviewed By: Clifford, William

QA Reviewer